



#### NOTES:

1. ASSEMBLE PARTS AS SHOWN. MACHINING ENTIRE SURFACE (INCLUDING HEAD OF BOLTS) TO DIMENSION SHOWN.
2. THE PARTS NEED TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN. THEN TO BE ELECTROPOLISHED BEFORE ASSEMBLY WITH BELLOW & FLANGE ASSEMBLY DWG.#P4105090104-810300
3. THIS IS A UHV SUB-ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
  - A) CIMCOOL 5 STAR 49
  - B) TRIM SOL
5. ALL DIMENSIONS WITH ARE MILLIMETERS

7		Ø1/2 x 1/2 LG. SHOULDER SCREW	SST (SILVER PLATED)	2
6		5/16-18 UNC-2B SOC HD SCR x 7/8 LG.	SST (SILVER PLATED)	2
5		Ø1/2 x 1/2 LG. SHOULDER SCREW	SST	2
4		5/16-18 UNC-2B SOC HD SCR x 7/8 LG.	SST	2
3	S3-230001-00	S3 LOWER MTG. PLATE	SST 304	1
2	A4-810202-03	A4 UPPER MTG. PLATE	SST 304	1
1	P4105090104-810201-02	A4 ROD WELDMENT		1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION				MATERIAL / SPEC	QTY
PARTS LIST							
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF					
TOLERANCES		ARGONNE NATIONAL LABORATORY					
DECIMALS		ANGULAR					
IN		° ' "					
FR		° ' "					
DECIMALS		ANGULAR					
IN		° ' "					
FR		° ' "					
SURFACE FINISH		125					
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.							
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. DIR.							
SUBMITTING & TO EXAMINE IN ACCORDANCE WITH LATEST ASST. DIR.							
NO NET SCALE DRAWING							
SEE PARTS LIST							
SCALE		HALF		SIZE		DRAWING NUMBER	
SHEET 22		C		S3-230000-00-2			